

Work Order ID 59206

Friday, May 28, 2010 9:19:11 AM



Page 1

Item ID: D3911-041

Accept



Setup Start



Revision ID:

Item Name: Basket Installation Stud Assembly, Lower

Stop



Start Date: 5/27/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 05-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3911

C

100



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

110



Small Fab

Small Fab

Memo

0.00

1- Assemble D3911-5 to D3911-1 and install rivet as per dwg
Trim rivet to 1.250" Full Length

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: SOASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

Memo

0.00

(0-6-23) Y001

10/06/24 JJ

C21016124

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

Friday, May 28, 2010 9:19:16 AM

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Work Order ID: 59206



Parent Item: D3911-041



Parent Item Name: Basket Installation Stud Assembly, Lower

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP RevA: New issue DD verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP Rev:C as per dwg
revC 10.04.07 Verified by:JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 5.0000	Qty per Kit 1	Total 10	Qty	Date	Status
D3911-1													

Basket Installation Stud, Lower

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		ST095	5		
		58786	5		

D3911-5



Manufactured No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST095	5	
58786	5	

Basket Stud Plate

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		ST095	16		
		57843	16		

MS20615-4M20



Purchased No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST095	16	
57843	16	

RIVET

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
		ST323	73		
		113254	7		
		114324	4		
		114349	62		

1114808 (30x)

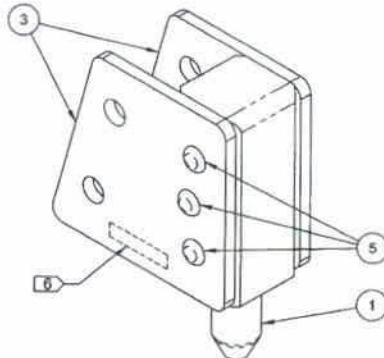
W/O:		WORK ORDER CHANGES					
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2	1		D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4	2		D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET

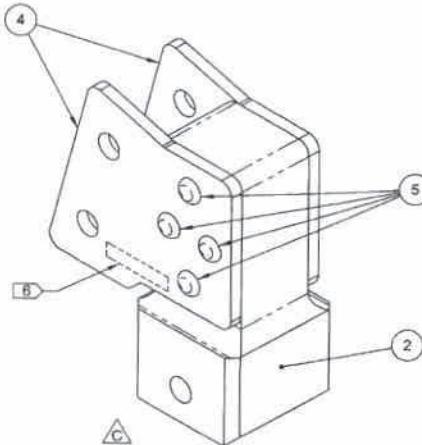


D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs

C



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 59204
BSR-5-28

D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-04-14
JPH

C	BOM: QTY (2): D4087-1 & MS21209-C810 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).		JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESIGN	JPH	DART AEROSPACE LTD	
	DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
	CHECKED		DRAWING NO. REV. C	
	MFG. APPR.		D3911 SHEET 1 OF 3	
	APPROVED		TITLE	
	DE APPR.		SCALE	
	DATE	10.04.06	NTS	

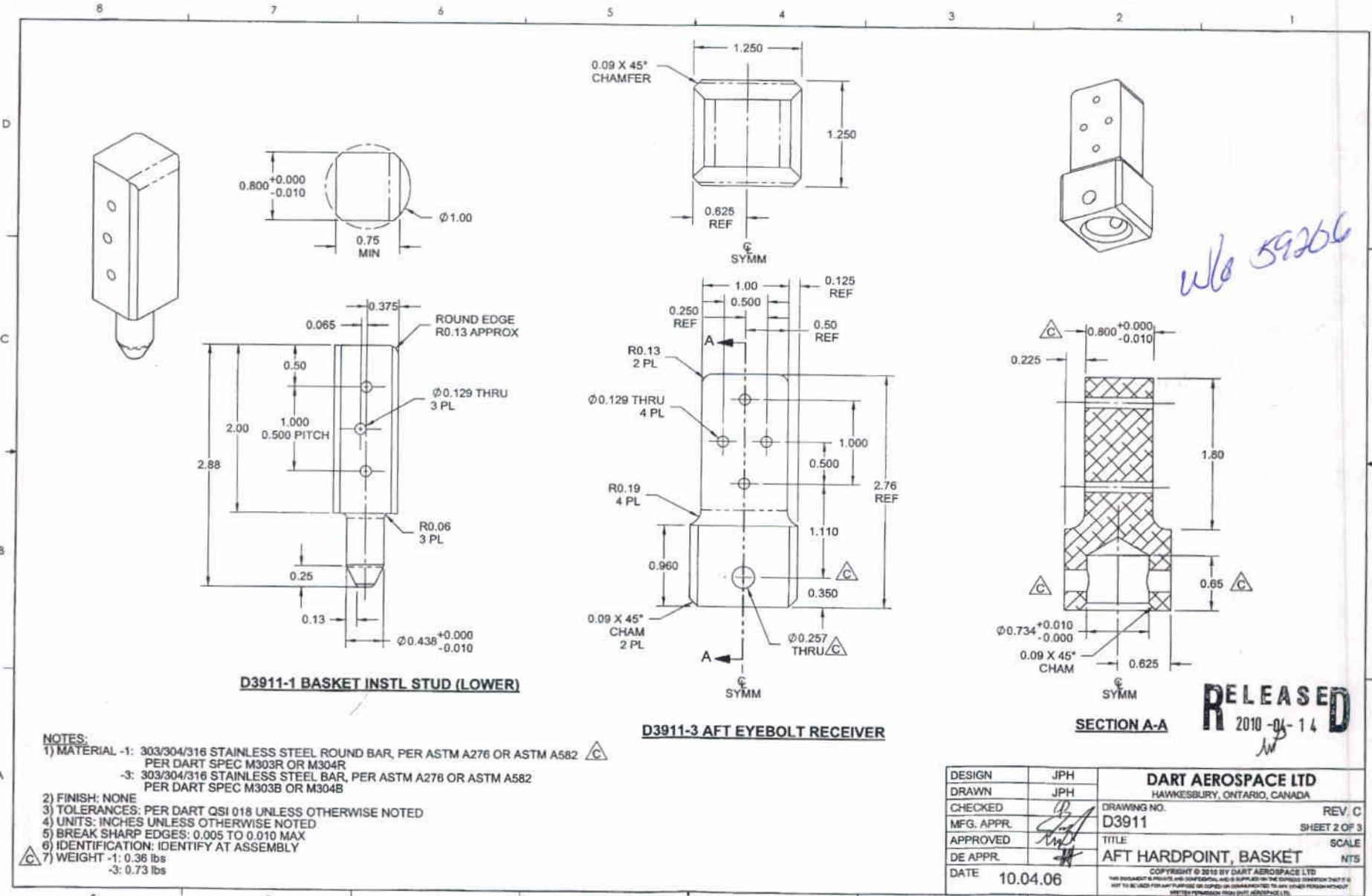
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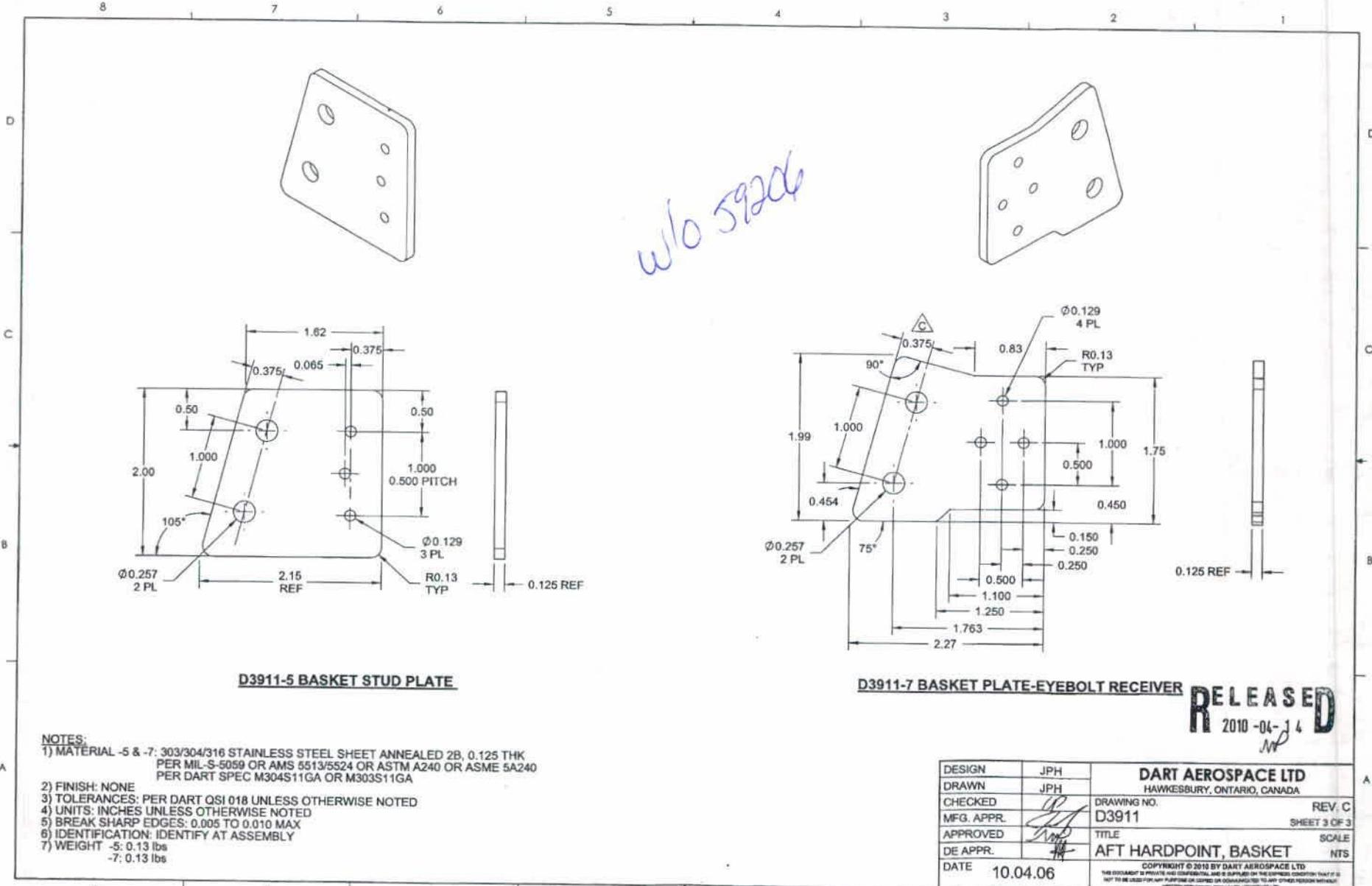


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NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT: -5: 0.13 lbs
-7: 0.13 lbs

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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